



Dart Aerospace Ltd.
1270 Aberdeen St
Hawkesbury, ON
K6A 1K7
Canada

Tel (613) 632-5200
Fax 613 632-5246

D2600-3-130
Job Sheet 182499



Part No: D2600-3-130

Job Qty: 127 ea *138 AT*

Part Name: Extrusion Round 3" 350



Part Weight: 0 lbs

Status: Scheduled

Priority: Medium

Job Created: 8/27/18

Job Tracking No:

Due Date: 10/24/18

Created By: Chantal Lavoie

Type: Stock

Description:

Note: DWG REV E

Ship Via:

Bill of Materials

Job Routing

Op No	Operation	Qty	Start Date	Due Date	Standard		Workcenter/Supplier		Sign-off
					Setup hrs	Run Hrs	Workcenter / Supplier	Lead Time	
100	Purchasing	127 pcs		10/24/18	0.00	0.00	Purchasing		<i>AP 18/11/05</i>
110	Packaging	127 pcs		10/24/18	0.00	0.00	Packaging2		<i>AT 18/11/05</i>
120	QC	127 pcs		10/24/18	0.00	0.00	QC18		<i>AT 18/11/05</i>
130	Packaging	127 pcs		10/24/18	0.00	0.00	Packaging3-1		<i>DD TF</i>
140	QC21-SA	127 Ea		10/24/18	0.00	0.00	QC21		<i>NOV 08 2018</i>

Part Op 100 - Issue P/O: *40854* a) Extrude as per Dwg D2600 (130" long) b) Material: 6061-T6 c) Material certification Descriptions: is required. ***EXTREME CARE MUST BE TAKEN TO PROTECT THE OUTSIDE SURFACE OF THE TUBE. THE OUTSIDE SURFACE MUST BE SMOOTH AND FREE FROM SURFACE DEFECTS SUCH AS SCRATCHES, NICKS, OR DENTS.*** **MUST BE WELL PACKAGE, IF NOT IT WILL BE REFUSE***

110 - Ensure material certification is attached

120 - Check Pull test per Dwg D2600 for compliance page attached Check hardness with Webster tester

130 - LOCATION : LG002

DAS
13
9-89

X127
AUG 27 2018

Job BOM

Part / Item	Component Name	Quantity	Operation	Container
D2600-3-130P	Extrusion Round 3" 350	127 pcs (1 ea)	100-Purchasing	<i>5124491</i>

Job Allocations

Operation	Component Part	Required	Inventory	Allocated
100-Purchasing	D2600-3-130P	127	0	0

NOV 8 0 1918

Part Specifications					
Spec No	Description	Target/Tolerance	Limits	Type	Special Comments
1	Extrusion	0.375inches $\pm$ 0.010	0.385 0.365		
2	Extrusion	2.810inches $\pm$ 0.032	2.842 2.778		
3	Extrusion	3.150inches $\pm$ 0.032	3.182 3.118		
4	Extrusion	2.840inches $\pm$ 0.032	2.872 2.808		
5	Extrusion	0.075inches $\pm$ 0.010	0.085 0.065		
6	Extrusion	0.155inches $\pm$ 0.010	0.165 0.145		
7	Extrusion	3.000inches $\pm$ 0.032	3.032 2.968		

Plex 8/27/18 8:56 AM dart.lavoie.chantal

SPECIFICATION CONTROL DRAWING

D2600-X-XXX EXTRUSION

NOTES:

- 1) MATERIAL: 6061-T6 ALUMINUM PER QQ-A-200/8 OR AMS-QQ-A-200/8 OR ASTM B221

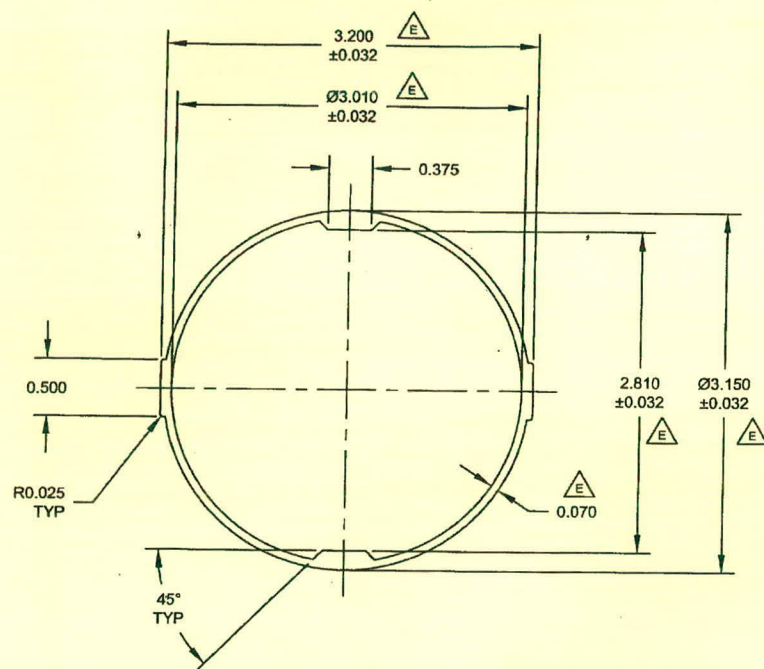
MINIMUM TENSILE YIELD STRENGTH = 35 KSI
MINIMUM ULTIMATE TENSILE STRENGTH = 40 KSI
MINIMUM ELONGATION = 8%

A SAMPLE FROM EACH BATCH WILL BE PULL TESTED TO ASTM STANDARD B221 BY AN APPROVED TESTING FACILITY TO ENSURE THAT THE BATCH MEETS THE ABOVE MINIMUM MECHANICAL PROPERTIES

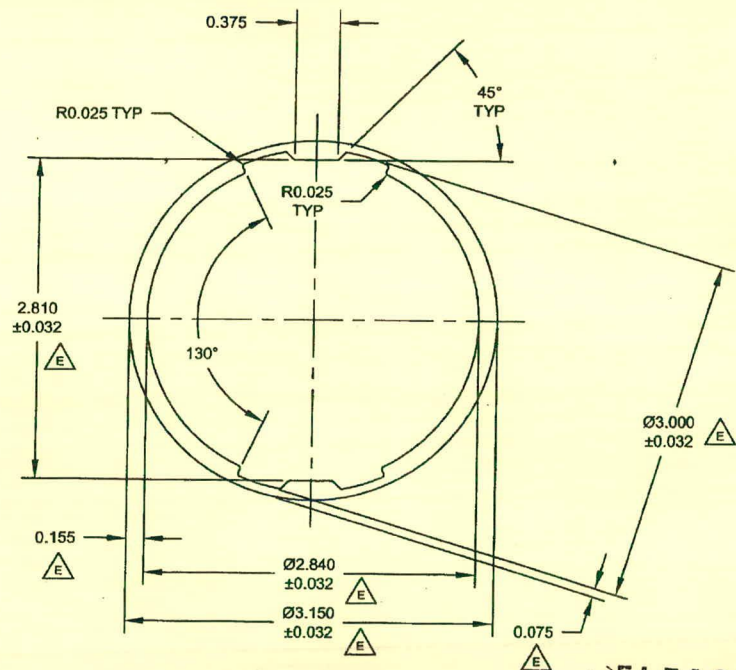
- 2) FINISH: N/A
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: IDENTIFY WITH DART P/N & B/N PER DART QSI 044 6.1 (FINE POINT PERMANENT INK MARKER)
- 7) WEIGHT: D2600-1 = 0.078 lb/in, D2600-3 = 0.130 lb/in, D2600-5 = 0.045 lb/in, D2600-7 = 0.091 lb/in
- 8) NO TOOLING MARKS
- 9) FOR D2600-1, PART NUMBER IS D2600-1-XXX WHERE XXX IS CUT LENGTH (EX. D2600-1-160 IS 160" LONG).
D2600-1 EXTRUSION MANUFACTURED FROM:
- CARADON INDALEX DIE # MH-18870
- SIGNATURE ALUMINUM (BON-L) DIE # 897121
- 10) FOR D2600-3, PART NUMBER IS D2600-3-XXX WHERE XXX IS CUT LENGTH (EX. D2600-3-120 IS 120" LONG).
D2600-3 EXTRUSION MANUFACTURED FROM:
- CARADON INDALEX DIE # MH-18859
- SIGNATURE ALUMINUM (BON-L) DIE # 897122
- 11) FOR D2600-5, PART NUMBER IS D2600-5-XXX WHERE XXX IS CUT LENGTH (EX. D2600-5-108 IS 108" LONG).
D2600-5 EXTRUSION MANUFACTURED FROM:
- CARADON INDALEX DIE # MS-18871
- 12) FOR D2600-7, PART NUMBER IS D2600-7-XXX WHERE XXX IS CUT LENGTH (EX. D2600-7-125 IS 125" LONG).
D2600-7 EXTRUSION MANUFACTURED FROM:
- CARADON INDALEX DIE # MS-18872

RELEASED
2012-01-11

E	REFORMAT DWG; ALL DIMS & TOL. UPDATE TO MATCH MFG DIE DWGS; ADD ASTM B221 SPEC (D8-1)	CP	11.10.18
D	INCREASE MIN. UTS TO 40 KSI	DS	98.08.20
C	ADD D2600-3, UPDATE D2600-1 WIDTH, ADD DIE NO.	DS	98.04.16
B	CHANGE MATERIAL SPEC.	DS	97.09.09
A	NEW ISSUE	DS	97.01.21
REV.	DESCRIPTION	BY	DATE
DESIGN	<i>[Signature]</i>	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
DRAWN	<i>[Signature]</i>		
CHECKED	<i>[Signature]</i>	DRAWING NO.	REV. E
MFG. APPR.	<i>[Signature]</i>	D2600	SHEET 1 OF 3
APPROVED	<i>[Signature]</i>	TITLE	SCALE
DE APPR.	<i>[Signature]</i>	EXTRUSION	NTS
DATE	11.10.18	COPYRIGHT © 1997 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD	



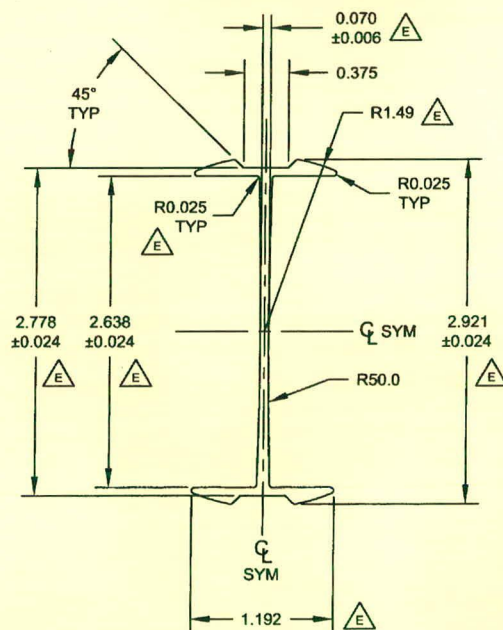
D2600-1 EXTRUSION



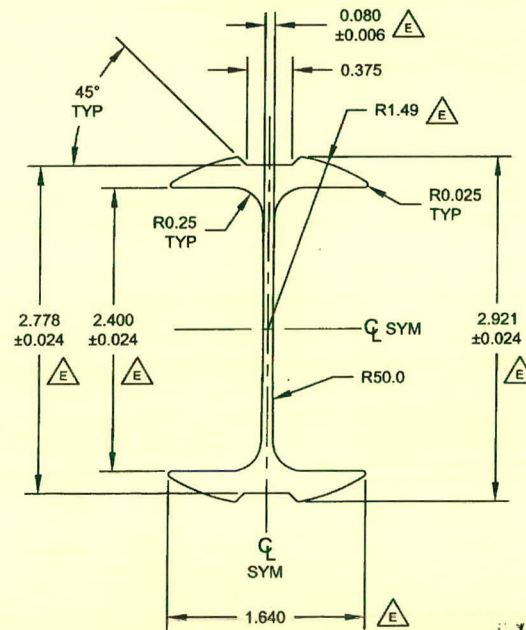
D2600-3 EXTRUSION

RELEASED
2012-01-11

DESIGN	1	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
DRAWN	1		
CHECKED	ASS	DRAWING NO.	REV. E
MFG. APPR.	E	D2600	SHEET 2 OF 3
APPROVED	1/10	TITLE	SCALE
DE APPR.	1/10	EXTRUSION	NTS
DATE	11.10.18	COPYRIGHT © 1997 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.	



D2600-5 EXTRUSION



D2600-7 EXTRUSION

RELEASED
68 2012-01-11
WJD

DESIGN	+	DART AEROSPACE LTD	
DRAWN	+	HAWKESBURY, ONTARIO, CANADA	
CHECKED	ASS	DRAWING NO.	REV. E
MFG. APPR.	EL	D2600	SHEET 3 OF 3
APPROVED	+	TITLE	SCALE
DE APPR.	+	EXTRUSION	NTS
DATE	11.10.18	COPYRIGHT © 1997 BY DART AEROSPACE LTD	
THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.			



Dart Aerospace Ltd.
1270 Aberdeen St
Hawkesbury, ON
K6A 1K7
Canada

Tel (613) 632-5200

PURCHASE ORDER **PO040854**

Supplier: SIG001-VC
Signature Aluminum Canada Inc.
C/O/ T10322C
PO Box 4488, STN A
TORONTO
ON
M5W 4H1 Canada
Phone: 905-427-6550
Fax: 905-427-2246

PO No: PO040854

PO Date: 8/27/18

Due Date: 10/24/18

Purchase Order

Revision:

Revision Date:

Ship-To Contact: Lavoie, Chantal
Phone: clavoie@dartaero.com

E-MAILED
AUG 27 2018

Ship To: 1270 Aberdeen Street
Hawkesbury
ON
K6A 1K7 Canada
Phone: 613-632-5200

Via: Ground

Pynt Terms: Net 30

Freight Terms:

Special Comments: QUOTE NO: 08272018-003

Items

Line Item	Job	Part	Supplier Part No	Description	Status	Account	Due Date	Order Quantity	Received Quantity	Balance	Unit Price (CAD)	Extended Price
1		D2600-3-130P		Extrusion Round 3" 350 : Extrude as per dwg D2600-3 REV. E EXTREME CARE MUST BE TAKEN TO PROTECT THE OUTSIDE SURFACE OF THE TUBE. THE OUTSIDE SURFACE MUST BE SMOOTH AND FREE FROM SURFACE DEFECTS SUCH AS SCRATCHES, NICKS, OR DENTS MUST BE WELL PACKAGE, IF NOT IT WILL BE REFUSE	Firmed	-	10/24/18	127 pcs	0 pcs ✓ 138x	127 pcs	\$45.403149/pcs	\$5,766.20

Grand Total: \$5,766.20

Order Notes



1850 Clements Road, Pickering Ontario, Canada L1W 3R8 INVOICING AND COMPANY LOCATION

Phone: (866) 587-5780 Fax: (905) 427-2207

Visit us at www.signaturealuminum.comSIGNATURE ALUMINUM CANADA
1850 CLEMENTS ROAD
PICKERING ON L1W 3R8

PACKING LIST

PACKING LIST DATE / DATE DU BORDÉREAU	
10-29-18	
PACKING LIST NUMBER / N° DE	
040023	
SALES ORDER NUMBER / N° DE COM	
133335	

ACCT# 46024

SHIP TO / EXPÉDIÉ À

DART AEROSPACE LTD.
1270 ABERDEEN ST.
HAWKESBURY, ON K6A 1K7
CANADA

PHONE: 613-632-5200

SOLD TO / VENDUE À

DART AEROSPACE LTD.
1270 ABERDEEN ST.
HAWKESBURY, ON K6A 1K7
CANADA

PHONE: 613-632-5200

ERMS / FREIGHT

PP

REFER TO
THESE NUMBERS ON
ALL CORRESPONDANCEREFEREZ-VOUS A CES
NUMEROUS POUR TOUTE
CORRESPONDANCE

CUSTOMER ID / ID DU CLIENT		ORDER DATE / DE LA COM		CUSTOMER PO NUMBER / CLIENT PO Nombre		JOB / FICHER		FIELD SALES REP / REP REGIONAL DES VENTES		CUST SERVICE REP / REP. SERVICE CLIENTELE	
46024		08/27/18		PO040854		MCGILLION		G.ATTENBOROU		S1S	
BILL OF LADING NUMBER / NO. DE CONNAISSEMENT		CARRIER / TRANSPORTEUR		SALES REP / REP. DES VENTES		SALES ORDER NUMBER / N° DE COM		SALES ORDER NUMBER / N° DE COM		SALES ORDER NUMBER / N° DE COM	
040023		MCGILLION		R. BLAIS		133335		133335		133335	
ITEM NO. / JUMÉRO	ORIGINAL ORDER QUANTITY / Quantité d'ordre ORIGINAL	UNIT / UNITÉ	PREVIOUS SHIPPED QUANTITY / PRÉCÉDENT Quantité livrée	MFG. PART NUMBER / MFG. PARTIE NUMÉRO	ALLOY & TEMPER / ALLIAGE & TEMPER	FINISH DESCRIPTION / DESCRIPTION DE FINITION	NBR OF PKGS / NBR DE PKGS	GROSS LBS / LIVRES BRUT	NET QUANTITY / QUANTITÉ NETTE	UNIT / UNITÉ	QUANTITY DUE / Quantité en raison
001	2,204	LB		DAA-897122-2	6061 T6		3	2,361	2,269	LB	
	1,000	KG		D2600-3-130P	130.0000 IN			1,071	1,029	KG	
Y	127	PC			Cut (+): 0.1180 Cut (-): 0.0000	Min: -10 % Max: 10 %			138	PC	
						906651 / 456356	1	787	756		46 PC
						906651 / 456357	1	787	756		46 PC
						906651 / 456358	1	787	756		46 PC

Transportation/Traffic damages and/or shortage claims are to be noted on the delivery copy of sellers shipping packing lists and signed and dated below by customers authorized representatives. No return materials will be accepted for credit without permission. The articles and/or services covered by this shipping packing list were produced in accordance with the fair labor standards act of 1938 as amended. Order accepted subject to the terms and conditions stated on our website.

Page 1 of 1

3	2,361	2,269	LB
	1,071	1,029	KG
		138	PC
TOTALS			

ACKNOWLEDGEMENT OF GOODS DELIVERED AND CONDITION

CUSTO

DATE OF DELIVERY

DRIVER

**SIGNATURE ALUMINUM CANADA**1850 CLEMENTS RD
PICKERING, ON L1W 3R8**CERTIFICATE OF COMPLIANCE**

Cert Date	Cert No.	Sales Order	Page
10/27/2018	5502465	133335	1
Cust PO	B/L No	Lot	Date
PO040854	040023	906651	10/29/18

Sold To	Ship To
46024 DART AEROSPACE LTD. 1270 ABERDEEN ST. HAWKESBURY, ON K6A 1K7 CANADA	46024 DART AEROSPACE LTD. 1270 ABERDEEN ST. HAWKESBURY, ON K6A 1K7 CANADA

Item No	Part No	Item Description	Cust Part
001	DAA-897122-2	130" Mill 6061 T6	D2600-3-130P
Gross Weight	2,361 LBS		
Net Qty	2,269 LBS 138 PCS 3 PKGS		
Specification		Die Desc	
AMS-QQ-A-200/8 & ASTM B221-08			

Mechanical Tests:

Tensile	Yield			
MPA / KSI	MPA / KSI	% Elongation	Conductivity	HRE
293.1 / 42.5	268.3 / 38.9	9.1	N/A	92

Chemical Analysis:

Si	Fe	Cu	Mn	Mg	Cr	Zn	Ti	V	Zr
0.63	0.26	0.22	0.10	0.88	0.06	0.03	0.01	0.01	0.00

*This Material is Made in Canada**This Material is RoHS Compliant*

This will certify that the material described herein has been inspected and tested in accordance with Signature Aluminum Canada's standard sampling and testing procedures or in accordance with the requirements of any specification forming a part of the material description to the extent indicated herein. Data of chemical composition for the material and test results from samples representative of the material are set forth above hereof or in any attachments hereto. This information shows that the material meets the applicable requirements. Inspection and test records are maintained on file. This certificate shall be deemed apart of and subject to the terms and conditions of warranty set forth on the reverse side of our order acknowledgement form. No other warranties are applicable.

S. Gooder
Quality Manager
Signature Aluminum Canada Inc

ISO 9001/TS16949 Registered Company

Visit us at www.signaturealum.com

Rev A

MATERIAL RECEIPT INSPECTION FORM

MATERIAL: D2620-3-130 (6061-T6)

PO / BATCH NO.: P0040854/5124441

DATE: 18/11/05

MATERIAL CERT REC'D: Kes

THICKNESS ORDERED: 0.075

QUANTITY RECEIVED: 138

THICKNESS RECEIVED: 0.075

QUANTITY INSPECTED: 138

SHEET SIZE ORDERED: —

QUANTITY REJECTED: 0

SHEET SIZE RECEIVED: —

DESCRIPTION	NCR (Check Y/N)		COMMENTS
SURFACE DAMAGE	Y	<u>(N)</u>	
CORRECT FINISH	<u>(Y)</u>	N	
CORROSION	Y	<u>(N)</u>	
CORRECT GRAIN DIRECTION	<u>(Y)</u>	N	
CORRECT MATERIAL PER M-DRAWING	<u>(Y)</u>	N	<u>AMS-QQ-A-228</u>
CORRECT THICKNESS	<u>(Y)</u>	N	
PHOTO REQUIRED	Y	<u>(N)</u>	
CORRECT REF # TO LINK CERT	<u>(Y)</u>	N	<u>P0040854</u>
CORRECT MATERIAL IDENTIFICATION	<u>(Y)</u>	N	
CORRECT M# ON THE MATERIAL	<u>(Y)</u>	N	
DOES THIS MATERIAL REQUIRE ENGINEERING SIGN OFF	Y	<u>(N)</u>	
DOES THIS REQUIRE AN EXTRUSION REPORT	Y	<u>(N)</u>	

CUT SAMPLE PIECE OF MATERIAL AND PREFORM A HARDNESS CHECK. RECORD RESULTS BELOW					
	HRC	HRB	DUR A	DUR D	WEBSTER
TYPE OF MATERIAL					
SIZE OF TEST SAMPLE					
HARDNESS / DUROMETER READING					

testers located in the Quality Office

QC 18 INSPECTION		ENGINEERING SIGNOFF (if required)	
INSPECTED BY: <u>AI</u>		SIGNED OFF BY: _____	
DATE: <u>18/11/05</u>		DATE: _____	

Attach this inspection sheet with the corresponding material cert and remit to be scanned and received in

